

83056

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/04/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 17/05/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLT

Date: 12/04/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Dart Aerospace Ltd

W/O: 83056		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2893-1 PAR #: _____ Fault Category: machining NCR: Yes No DQA: [Signature] Date: 12/05/30
 Resolution: use as is Disposition: use as is QA: N/C Closed: [Signature] Date: 12/5/31

NCR: 12-1461		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/23	100	Didn't see an offset in the folio, therefore the dimension AG is undersized by .005" measuring 0.135" should be 0.140" to 0.160" R.C. operation error.	CP 12.05.23 [Signature]	Acceptable	FKV 12/05/23	[Signature] 12/05/23	CP 12.05.23 [Signature]	[Signature] 12/05/23

NOTE: Date & initial all entries

Work Order ID 83056

83056

Page 2

April-12-12 1:30:13 PM

Item ID: D2893-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 2.75 Support

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

AL 12 - 5 - 24 (20)

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

nl 12 05 28 (20)

170

Identify as per dwg & Stock Location: *X-tube*

0.00

170

Packaging

Memo

0.00

Packaging

Assy

nl 12 05 28 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83056***83056***

Page 3

April-12-12 1:30:13 PM

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 2.75 Support

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/15/29 AG

ML5 12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:30:17 PM

Page 1

Work Order ID: 83056

83056

Parent Item: D2893-1

D2893-1

Parent Item Name: 2.75 Support

Start Date: 12/04/2012

Required Date: 17/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

11.08.04 as per dwg rev.C DD verf:EC

IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10.52632			

DSK078

D2893-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT

-10

MAT060

10

82952

10

FK 12/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83056
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.991	2.995	2.991	2.991	2.991
AB	0.440	0.460		.445	.442	.450	.450	.450
AC	0.125	0.160		.140	.127	.140	.135	.138
AD	0.040	0.060		.050	.050	.050	.050	.0485
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.143	.140	.143	.143
AG	0.140	0.160		.149	.150	.147	.150	.1495
AH	1.360	1.400		1.373	1.376	1.3735	1.3715	1.375
AI	0.040	0.060		.054	.0495	.0495	.053	.050
AJ	1.190	1.230		1.219	1.220	1.2175	1.218	1.218
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.528	2.530	2.533	2.534
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.260
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	JJ 12/05/18	Date:	12/05/19
Audited by:	ML	Date:	12/05/23
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83056
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

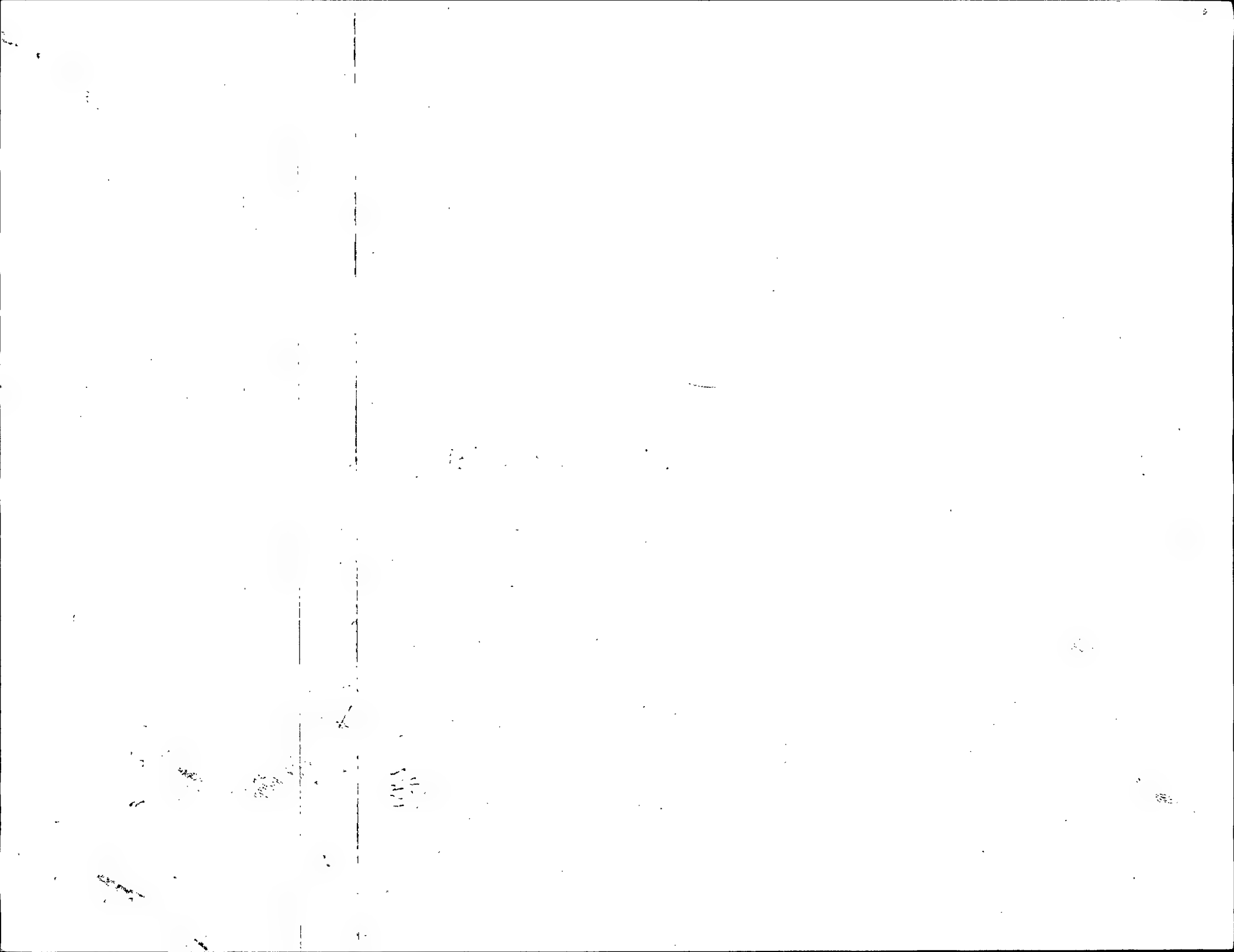
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 ✓	7 ✓	8 ✓	9 ✓	10 ✓
HAAS Section								
AA	2.985	3.005		2.991	2.992	2.990	2.989	2.991
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.134	.130	.130	.132	.130
AD	0.040	0.060		.049	.048	.050	.048	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.145	.145	.142	.143	.140
AG	0.140	0.160		.148	.148	.147	.148	.148
AH	1.360	1.400		1.3745	1.375	1.373	1.373	1.3735
AI	0.040	0.060		.050	.049	.051	.0525	.052
AJ	1.190	1.230		1.220	1.2175	1.218	1.220	1.2195
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: SL Date: 12/05/20

Audited by: am Date: 12/05/23

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	



DART AEROSPACE LTD		Work Order:	83056
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.990	2.991	2.990	2.990	2.990
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.049	.050	.050	.048	.048
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.128	.130	.136	.140
AG	0.140	0.160		.148	.148	.148	.148	.149
AH	1.360	1.400		1.373	1.375	1.3735	1.373	1.372
AI	0.040	0.060		.049	.052	.051	.051	.051
AJ	1.190	1.230		1.217	1.220	1.2175	1.218	1.217
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	12/05/21
Audited by:	<i>[Signature]</i>	Date:	12/05/23
Prototype Approval:	<i>[Signature]</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	<i>[Signature]</i>
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	83056
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 μ	17 μ	18 μ	19 μ	20 μ
HAAS Section								
AA	2.985	3.005	2.990	2.990	2.990	2.990	2.991	2.997
AB	0.440	0.460	0.450	.450	.450	.450	.450	.440
AC	0.125	0.160		.130	.128	.130	.129	.133
AD	0.040	0.060		.049	.050	.049	.049	.049
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.147	.145	.147	.147	.135
AH	1.360	1.400		1.3735	1.373	1.373	1.3735	1.377
AI	0.040	0.060		.049	.049	.049	.051	.040
AJ	1.190	1.230		1.217	1.219	1.218	1.217	1.199
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	12/05/21
Audited by:	<i>[Signature]</i>	Date:	12/05/23
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries